

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004970**Date Inspected:** 11-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

CWI Name:	Peng Wen Jun and Wang Wen Bin			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

OBG bottom plate.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed welds made between assembly component members on the inspection part numbers identified as follows: BP043A-001, BP044A-001, BP178A-001 and BP125A-001 (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001620 item numbers 3, 5, 6 and 7 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel Peng Wen Jun and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

OBG floor beam.

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2. The QA Inspector performed a random VT and MT verifications on the completed welds made between assembly component members on the inspection part numbers identified as follows: BP024-004 (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001619 item numbers 1 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel Wang Wen Bin and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

80.75M diaphragm.

3. The QA Inspector performed a random VT and MT verifications on the completed welds made between assembly component members on the inspection part numbers identified as follows: SSD1-SA362- welds 13, 14 and SSD1-SA421- welds 1, 2. Please note that the verifications performed on these inspection parts at this location were performed without a ZPMC Non Destructive Examination (NDE) notification of witness inspection document. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

SKIN E LIFT 2

4. The QA Inspector was requested by ZPMC QC Inspection personnel to perform visual verification on completed welds made between longitudinal stiffeners and skin plate on the inspection part identified as "SKIN "E" LIFT 2 TOWER". The request was submitted after QC Inspection personnel had completed the inspections and reported the welds and base material to be acceptable and ready for verification. During verification the QA Inspector did not observe any discontinuities on the welds, but did observe several welding related discontinuities on the base material (ark strikes and base material discontinuities) and notified QC Inspector An Qing Xiang. QC Inspector directed the ZPMC personnel to remove the welding related defects. ZPMC personnel performed grinding to remove discontinuities. After the grinding was completed the QA Inspector observed the defects were removed and notified QC Inspector An Qiang Xiang the welds appeared to be acceptable as of this time. Please note that the ZPMC personnel are still performing grinding on the skin plate component members due to in process fabrication. The QA Inspector notified Lead QA Inspector Paul Dawson of observations during verification.

Summary of Conversations:

As noted in the body of the report above.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
